

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014295**Date Inspected:** 11-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 11AW , weld No. CA80-003. The welder is identified as #067571. ZPMC QC is identified as Mr. Tang Ya Jin . The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 11AW , weld No. CA79-004. The welder is identified as #044772. ZPMC QC is identified as Mr. Tang Ya Jin . The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 2F position for the OBG Segment 11AW , weld No. SSD13A-PP95-046. The welder is identified as #044790. ZPMC QC is identified as Mr. Tang Ya Jin. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 3F position for the OBG Segment 10BW, weld No. SSD13-PP89-004. The welder is identified as #201583. ZPMC QC is identified as Mr. Tang Ya Jin. The welding variables recorded by QC appear to comply

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with WPS-B-T-2133.

### Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG U-rib to stiffener Plate.

The weld designations reviewed are as follows:

DP3118-001-205,206  
DP3118-001-244,245  
DP3118-001-318,319  
DP3143-001-159,160  
DP3145-001-206,207

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Deck Plate Splice joints.

The weld designations reviewed are as follows:

DP3126-001-001,002  
DP3082-001-001,002

During Quality Assurance random in-process observations of the fabrication of segment 12CW, this Quality Assurance Inspector (QA) discovered the following issues that ZPMC was welding two(2) complete joint penetration (CJP) butt joints without utilizing Weld Tabs (Run off Plates). The joints are identified as SEG3006F-143 and SEG3006D-126. After that the QA Inspector informed to ZPMC QC Mr. Li Ming Yang to grind the area and perform Magnetic Particle Testing at that mention area.

The QA inspector did not generate any incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

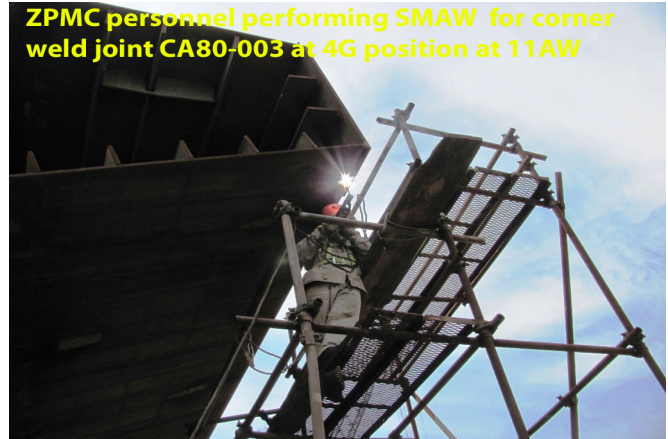
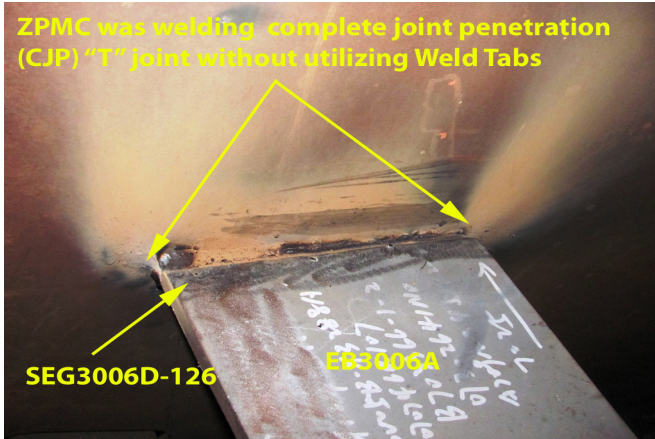
No relevant conversations

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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